

Date: Monday, 23/03/2009 9:53:17 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 A/B LOW GEAR WEB
Job Number :	46636		
Estimate Number :	11768		
P.O. Number :		Part Number :	D26541
This Issue :	23/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2654 REVE1
First Issue :	/ /	Project Number :	N/A
Previous Run :	46437	Drawing Revision :	E1
	Type :	Material :	
	SKIDTUBES	Due Date :	30/03/2009
Written By :		Qty:	2
Checked & Approved By :	<u>JLD 09-03-23</u>	Um:	Each
Comment :	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D26005108	Extrusion 'I Beam' thin
-----	-----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit' Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	

B38589 *Pr* 09-03-23 (2)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654 (73.85")

2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

Pr 09-03-23 (2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

RE 09-03-23 (2)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Pr 09-03-23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:53:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 46636

Part Number: D26541

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

② 4 9-3-23

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

AM 09-03-23 ②

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 JF

Job Completion



mf 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

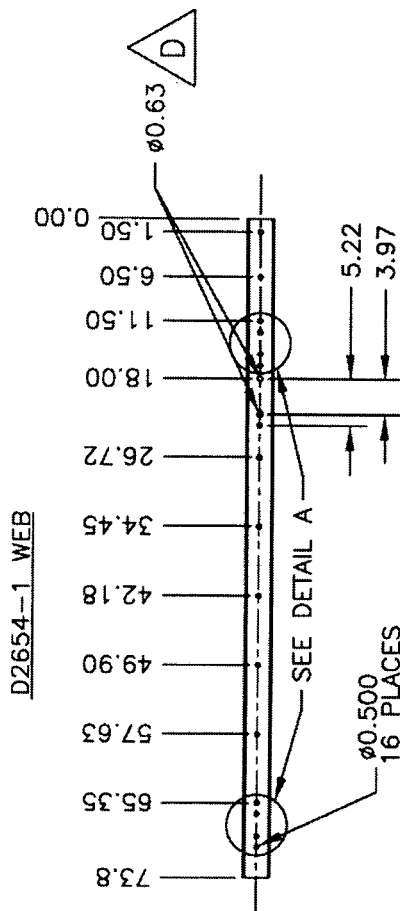
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

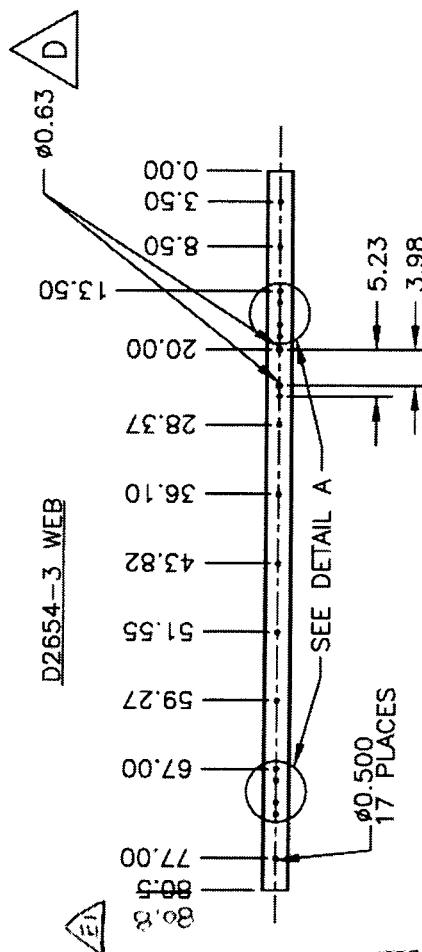
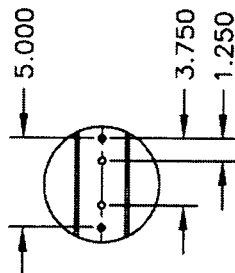


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2654	SHEET 1 OF 2
DATE	TITLE		SCALE
04.05.26	WEB		1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	04.08.04	PER TOOLING, 80.8 WAS 80.5	

RELEASED
04.06.22



DETAIL A
SCALE 1:10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46630

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

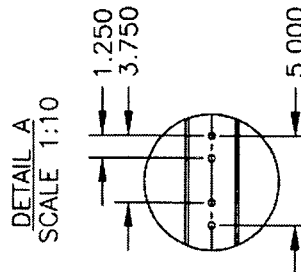
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

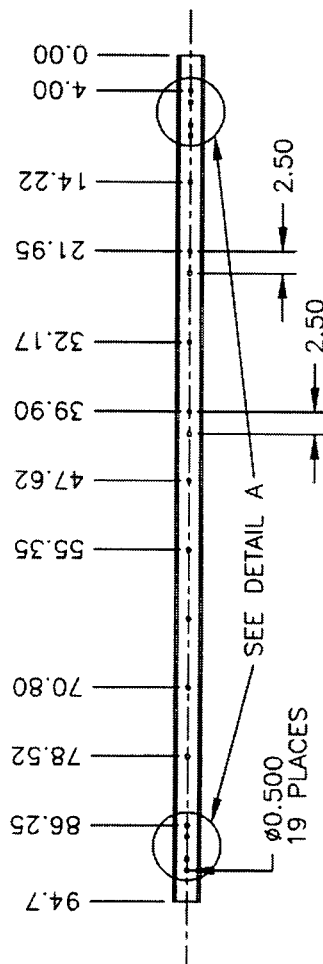


DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

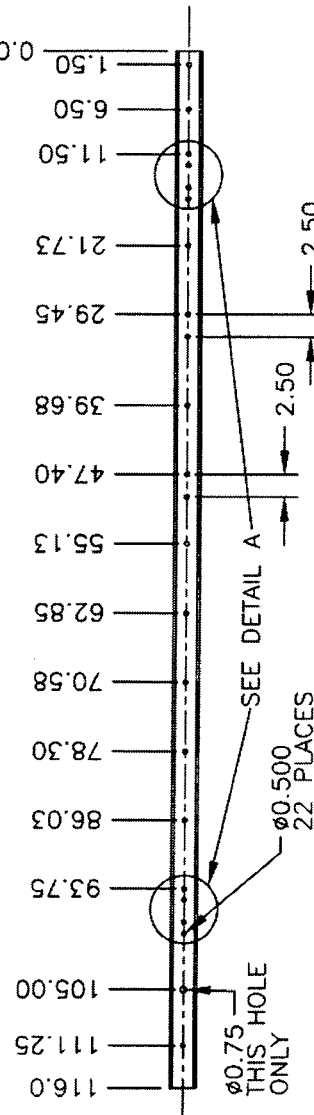
RELEASED
04.06.22



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4603*

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.